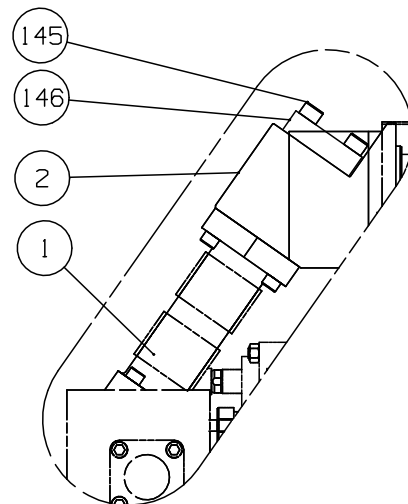


## ASSEMBLY NOTES:

1. PRIOR TO ASSEMBLY ALL SEALS, GLYD RINGS, O-RINGS & WEAR RINGS SHOULD BE WET WITH HYDRAULIC OIL. ALL PARTS MUST BE CLEAN.
2. ORIENTATION OF SEALS MUST BE AS SHOWN.
3. FOR OIL LEVEL INSTRUCTIONS REFER TO MACHINE MANUAL.
4. FOR LUBRICATION POINTS & LUBRICANTS REFER TO MACHINE MANUAL.
5. SCREWS REQUIRE LUBRICANT FOR ASS'Y, USE "LUBRIPLATE 3000" HPN 664682 AND "OPTIMOLY PASTE TA" HPN 664751 FOR SCREWS WITH HIGH WORKING TEMPERATURES.
6. SOME GEOMETRY IS REMOVED FOR CLARITY OF THE DRAWING.

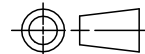
VIEW USE ONLY WITH BARREL  
'B' HEAD FILTER OPTION

WEIGHT - kg

UNLESS OTHERWISE SPECIFIED, TORQUE:			
FASTENERS -		CHART BELOW	
SIZE	Nm	HUSKY SPEC -	HGT-FT
M6	10		7
M8	18		18
M10	25		40
M12	35		70
M14	50		95
M16	70		180
M18	90		200
M20	120		290
M24	180		490
M30	270		960
M36	370		1700
M42	550		2700
M48			4000

APPLY PROPER LUBRICANT TO ALL THREADS &  
CONTACTING SURFACES BEFORE INSTALLATION.

METRIC



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SYSTEMS LTD. ALL RIGHTS RESERVEDTITLE  
INJECTION ASSEMBLY  
G-LINE PET P2

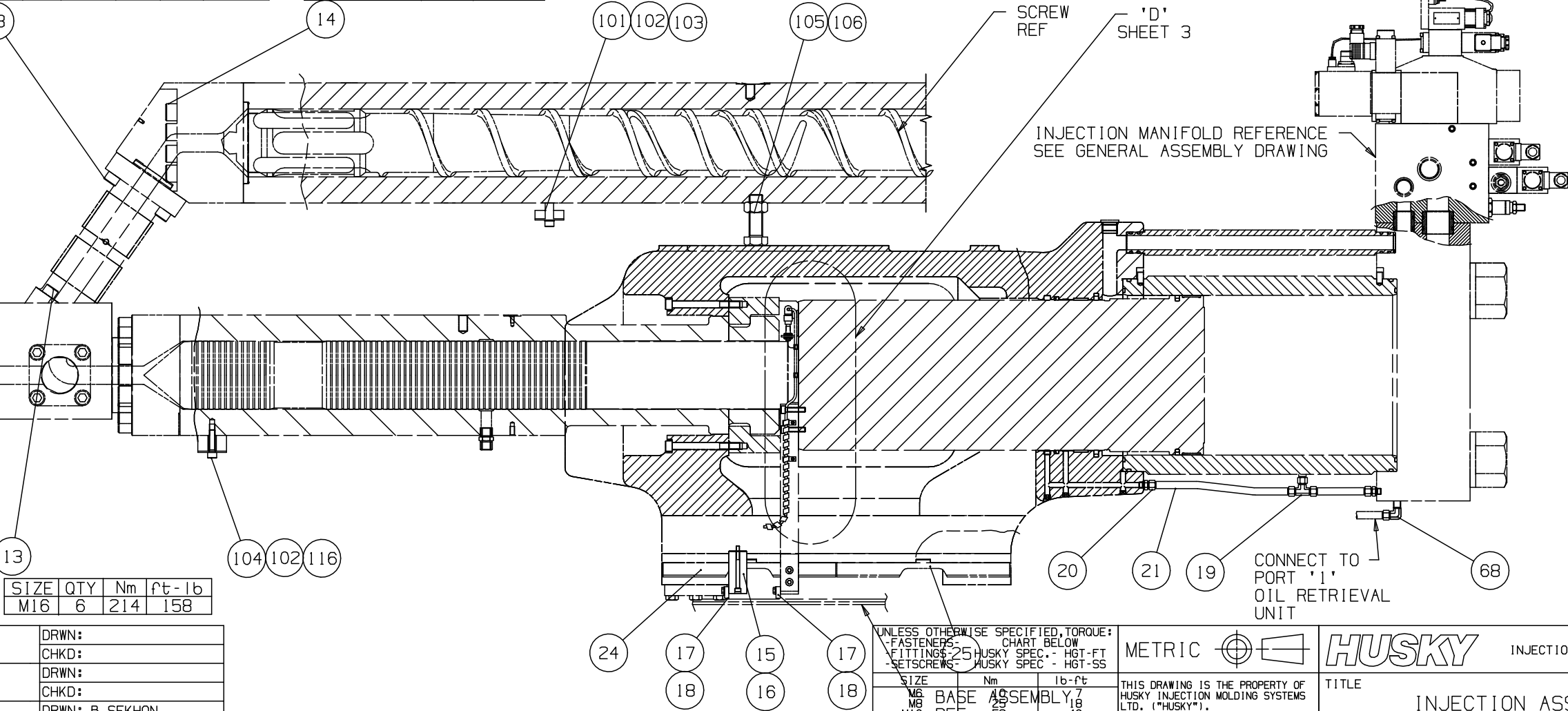
SCALE	NTS	SIZE	DRAWING	REV
SHEET 1 OF 7		A3	2303471	2

REV	DATE	NAME
2	2001-01-19	DRWN: B. SEKHON CHKD:
1	00-09-27	DRWN: G. SOLT I CHKD: M. NEMEC
0	2000-08-08	DRWN: B. SEKHON CHKD:

NOTE:  
7. ALL PINS & BUSHINGS TO BE COATED WITH LUBRICANT HPN 696686 (TEFLON LUBE KLEEN-FLO) EXCEPT WHERE SHOWN OTHERWISE

UNIT	MC	SIZE	QTY	Nm	ft-lb
E85/E100	32	M16	6	128	95
E100/E120	38	M16	6	155	115
E140	38	M16	6	195	145

SIZE	QTY	Nm	ft-lb
M16	8	155	115
M20	8	325	240
M24	8	540	400



SIZE	QTY	Nm	ft-lb
M16	6	214	158

2	2001-01-19	DRWN: B.SEKHON CHKD: M.NEMEC
1	00-09-27	DRWN: G.SOLT CHKD: M.NEMEC
0	2000-08-08	DRWN: B.SEKHON CHKD: M.NEMEC
REV	DATE	NAME

WEIGHT - kg

SIZE	Nm	lb-ft
M6	10	7
M8	15	11
M10	20	15
M12	25	18
M14	30	22
M16	35	26
M18	40	30
M20	45	33
M24	55	40
M30	70	52
M36	90	66
M42	110	81
M48	130	95

UNLESS OTHERWISE SPECIFIED, TORQUE:  
FASTENERS - CHART BELOW  
FITTINGS - HUSKY SPEC - HGT-FT  
SCREWS - HUSKY SPEC - HGT-SS

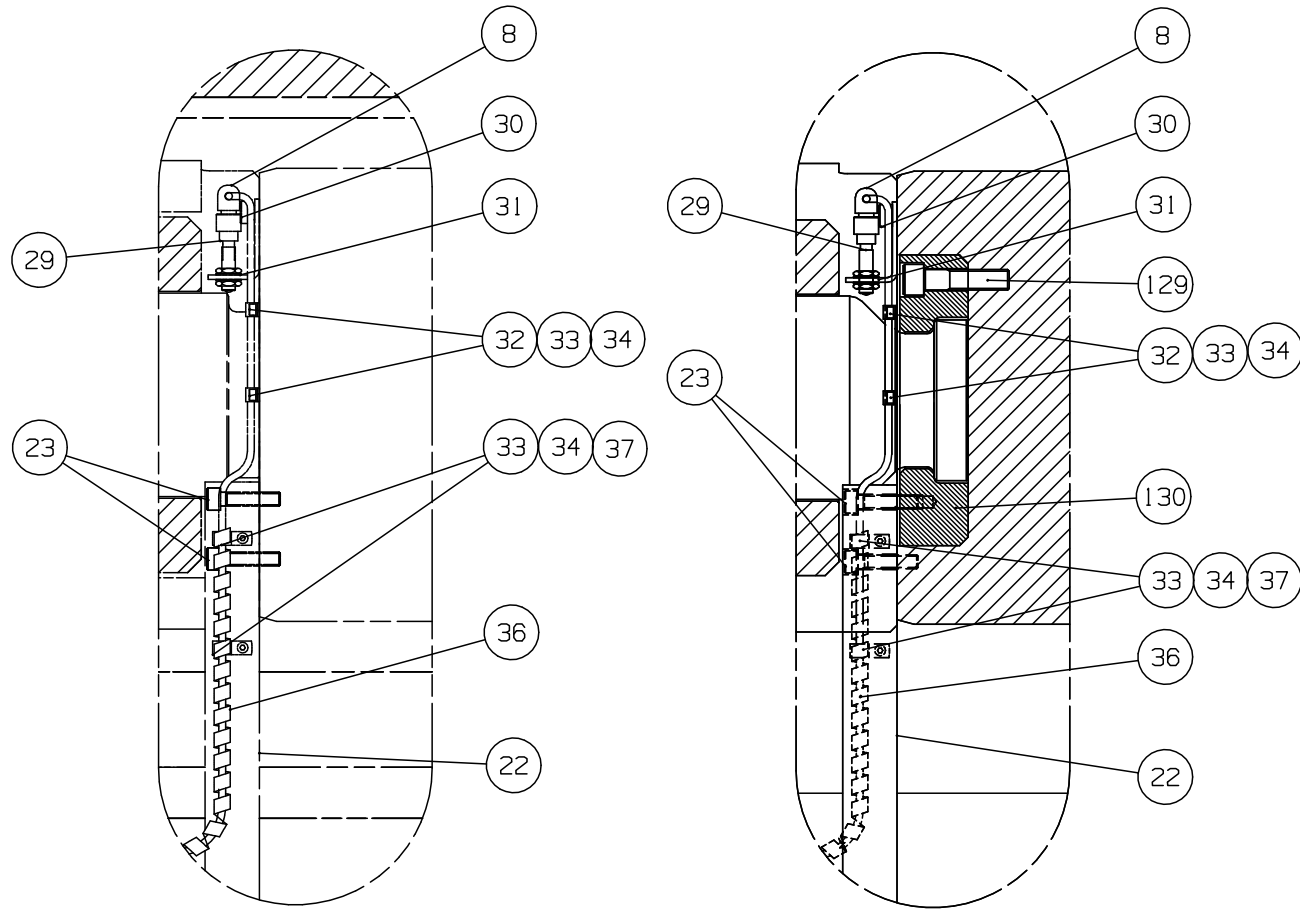
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METRIC		INJECTION MOLDING SYSTEMS LTD
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SCALE	NTS	SIZE
SHEET 2 OF 7		A3
DRAWING		2303471
REV		2

1

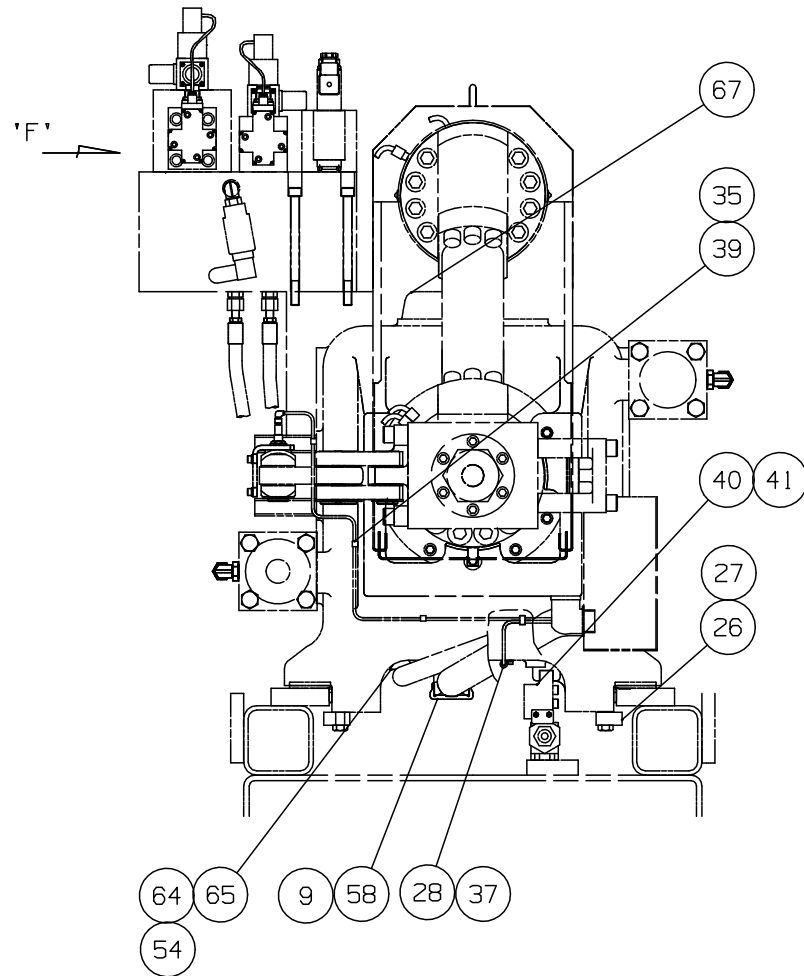
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REV 2  
DRAWING 2303471

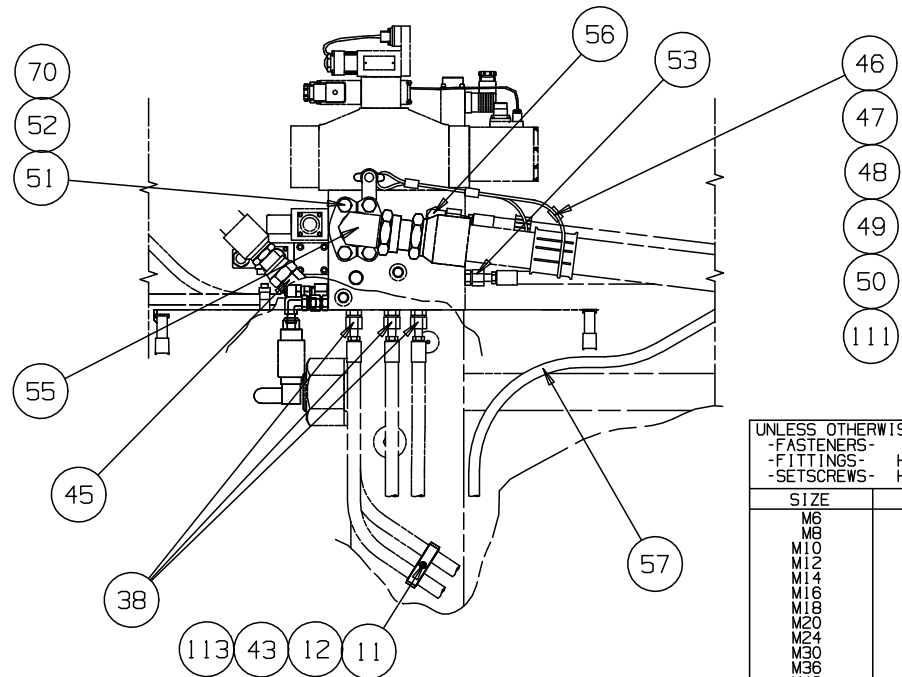


VIEW 'D'  
STANDARD CONFIGURATION

VIEW 'D'  
USE ONLY WITH PULLBACK OPTION



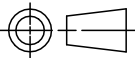
VIEW 'E'  
SHEET 4



VIEW F  
WEIGHT - kg

		DRWN:
		CHKD:
		DRWN:
		CHKD:
2	2001-01-19	DRWN: B.SEKHON
		CHKD:
1	00-09-27	DRWN: G.SOLT I
		CHKD: M.NEMEC
0	2000-08-08	DRWN: B.SEKHON
		CHKD:
REV	DATE	NAME

UNLESS OTHERWISE SPECIFIED, TORQUE:		
-FASTENERS- CHART BELOW		
-FITTINGS- HUSKY SPEC - HGT-FT		
-SETSCREWS- HUSKY SPEC - HGT-SS		
SIZE	Nm	lb-ft
M6	10	7
M8	18	13
M10	25	18
M12	40	30
M14	70	52
M16	95	70
M18	180	133
M20	270	200
M24	390	290
M30	660	490
M36	1300	960
M42	2300	1700
M48	3700	2700
	5500	4000
APPLY PROPER LUBRICANT TO ALL THREADS & CONTACTING SURFACES BEFORE INSTALLATION.		

METRIC 		<h1>HUSKY</h1>		INJECTION MOLDING SYSTEMS LTD	
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		INJECTION ASSEMBLY G-LINE PET P2			
		SCALE    NTS		SIZE	DRAWING
SHEET   3 OF 7		A3	2303471		2

1

2

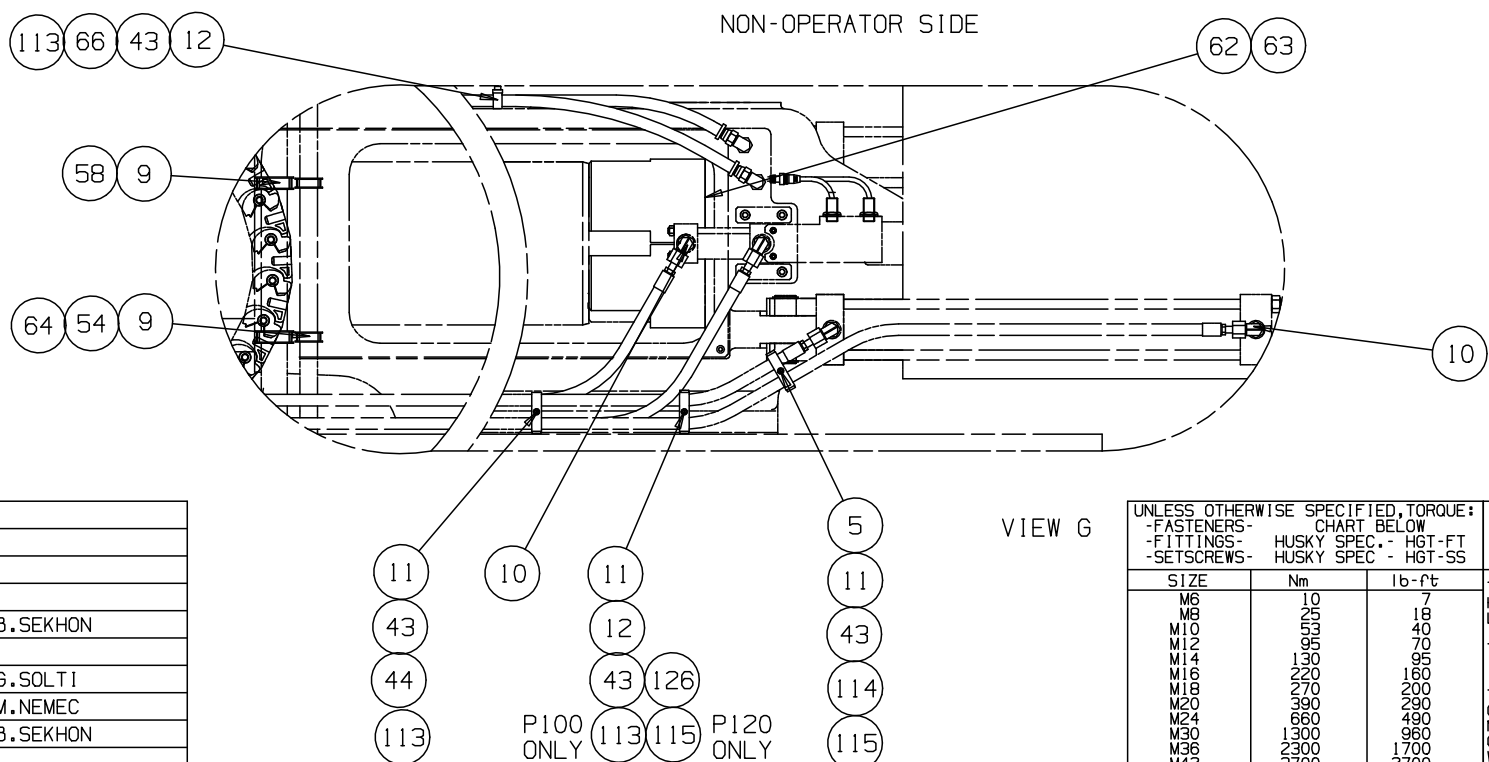
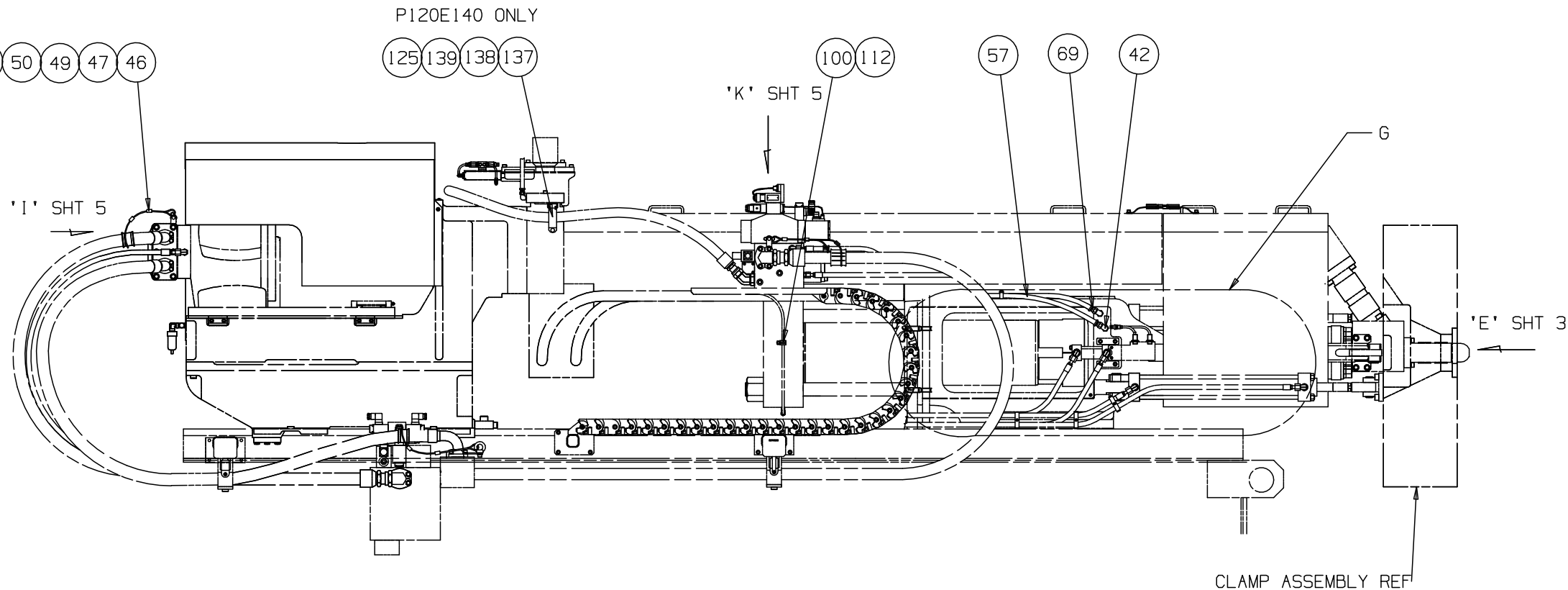
DRAWING 2303471  
REV 2

A

A

B

B



VIEW G

UNLESS OTHERWISE SPECIFIED, TORQUE:		
FASTENERS- CHART BELOW		
SIZE	Nm	lb-ft
M6	10	7
M8	25	18
M10	50	40
M12	75	70
M14	130	95
M16	220	160
M18	270	200
M20	390	290
M24	660	490
M30	1300	960
M36	2300	1700
M42	3700	2700
M48	5500	4000

APPLY PROPER LUBRICANT TO ALL THREADS & CONTACTING SURFACES BEFORE INSTALLATION.

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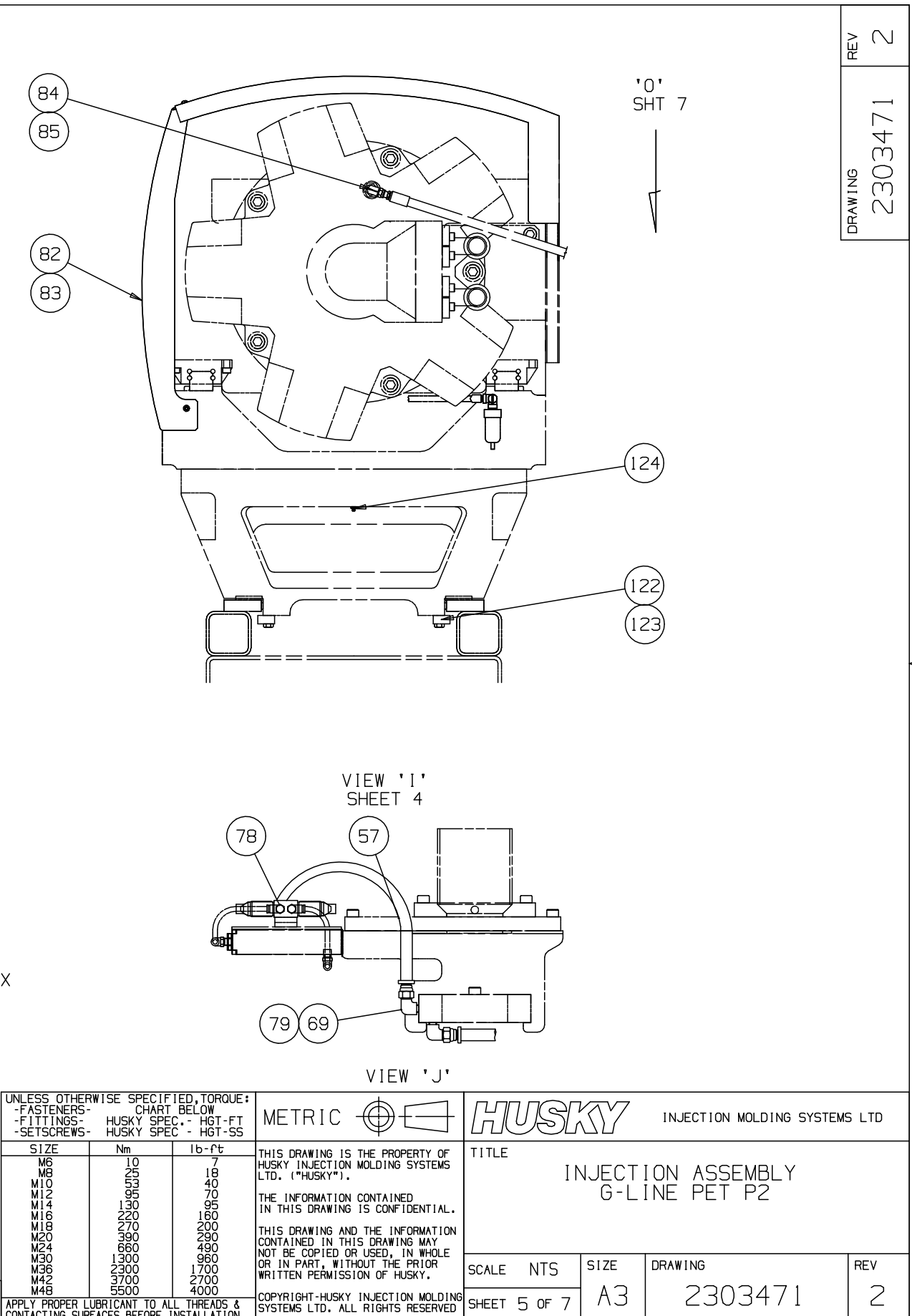
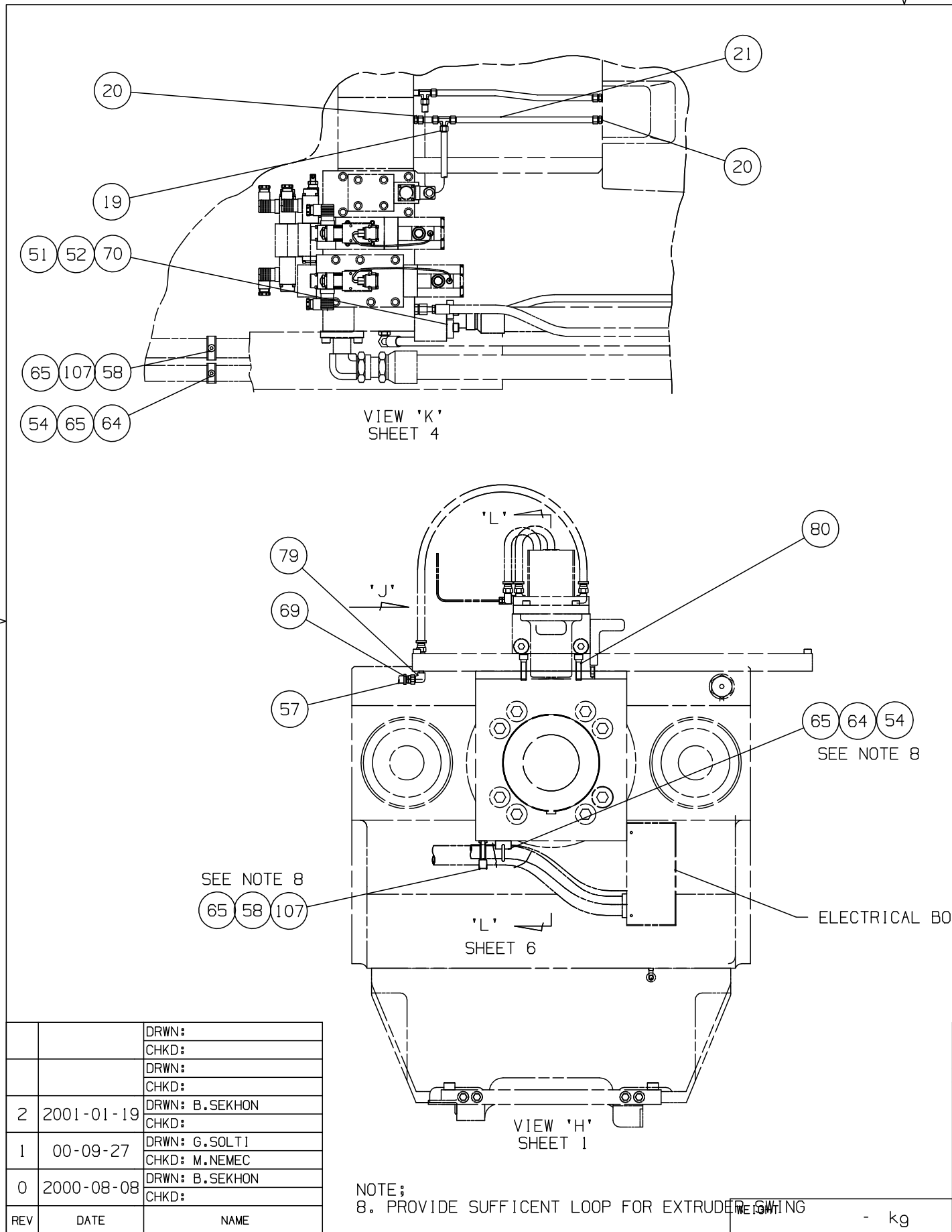
TITLE  
INJECTION ASSEMBLY  
G-LINE PET P2

SCALE	NTS	SIZE	DRAWING	REV
SHEET 4 OF 7		A3	2303471	2

		DRWN:
		CHKD:
		DRWN:
		CHKD:
2	2001-01-19	DRWN: B.SEKHON
		CHKD:
1	00-09-27	DRWN: G.SOLT I
		CHKD: M.NEMEC
0	2000-08-08	DRWN: B.SEKHON
		CHKD:
REV	DATE	NAME

1

2

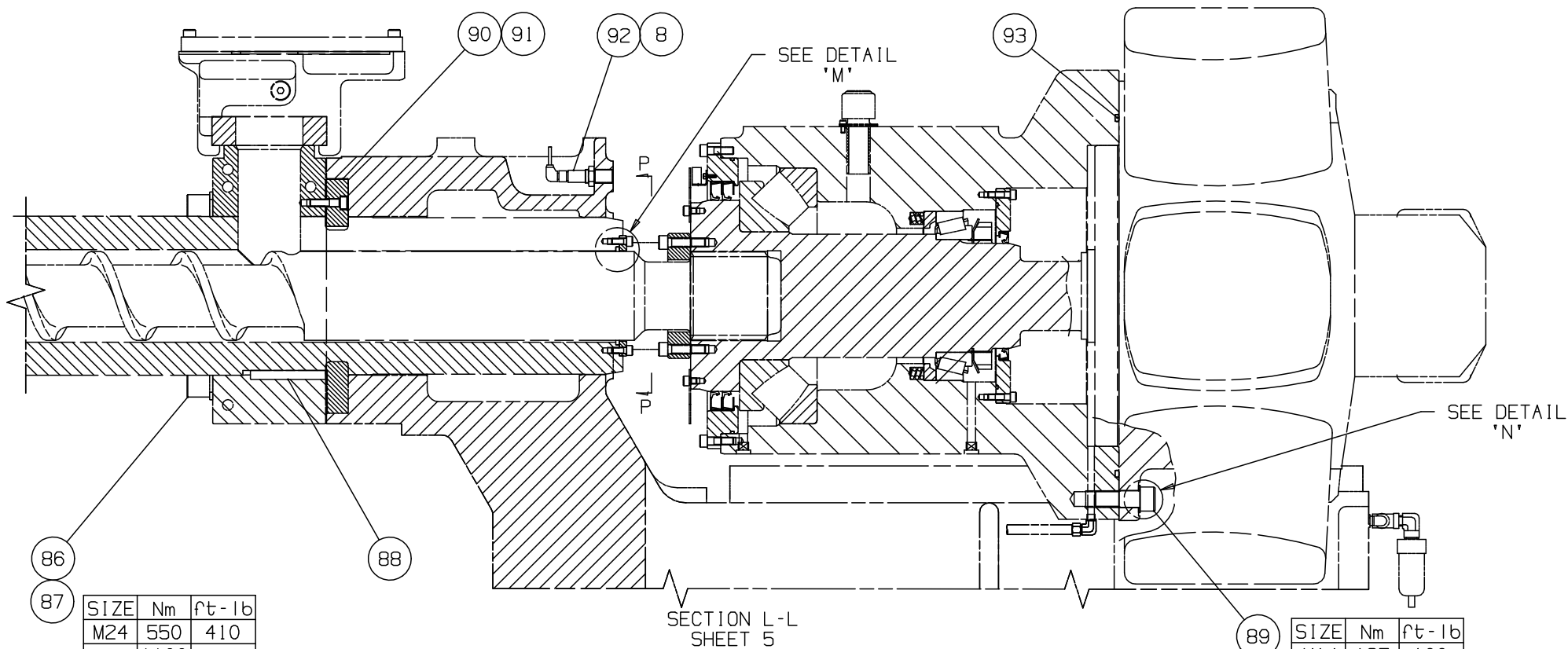


REV	2
DRAWING	2303471

1

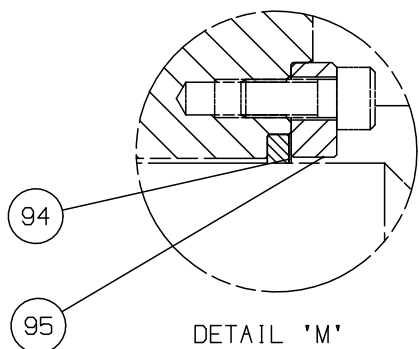
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DRAWING 2303471  
REV 2

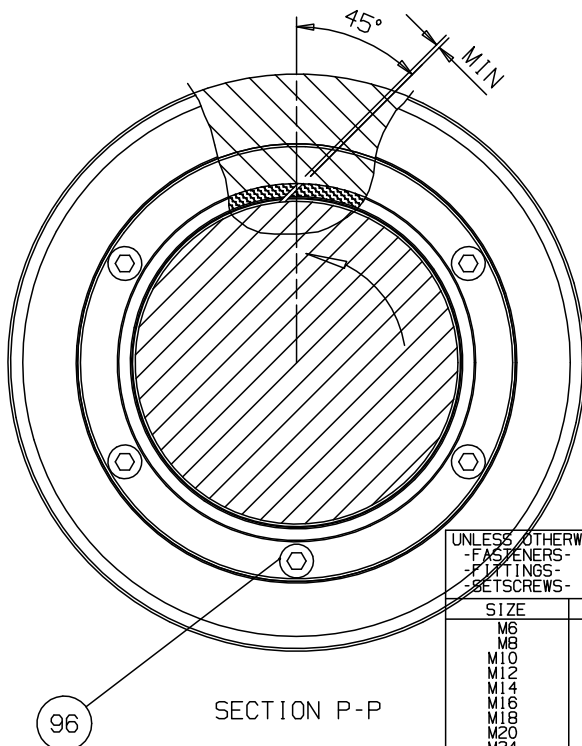


SIZE	Nm	ft-lb
M24	550	410
M30	1100	810

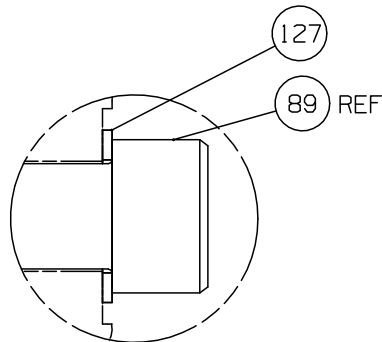
SIZE	Nm	ft-lb
M14	135	100
M18	260	190
M22	435	320



DETAIL 'M'



SECTION P-P



DETAIL 'N'  
USE FOR E140 ONLY

		DRWN:	
		CHKD:	
		DRWN:	
		CHKD:	
2	2001-01-19	DRWN: B.SEKHON	
		CHKD:	
1	00-09-27	DRWN: G.SOLT1	
		CHKD: M.NEMEC	
0	2000-08-08	DRWN: B.SEKHON	
		CHKD:	
REV	DATE	NAME	

WEIGHT - kg

UNLESS OTHERWISE SPECIFIED, TORQUE:		
FASTENERS- CHART BELOW		
SIZE	Nm	lb-ft
M6	10	7
M8	25	18
M10	55	40
M12	95	70
M14	135	95
M16	220	160
M18	270	200
M20	390	290
M24	660	490
M30	1300	960
M36	2300	1700
M42	3700	2700
M48	5500	4000

APPLY PROPER LUBRICANT TO ALL THREADS & CONTACTING SURFACES BEFORE INSTALLATION.

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TITLE  
INJECTION ASSEMBLY  
G-LINE PET P2

SCALE	NTS	SIZE	DRAWING	REV
		A3	2303471	2

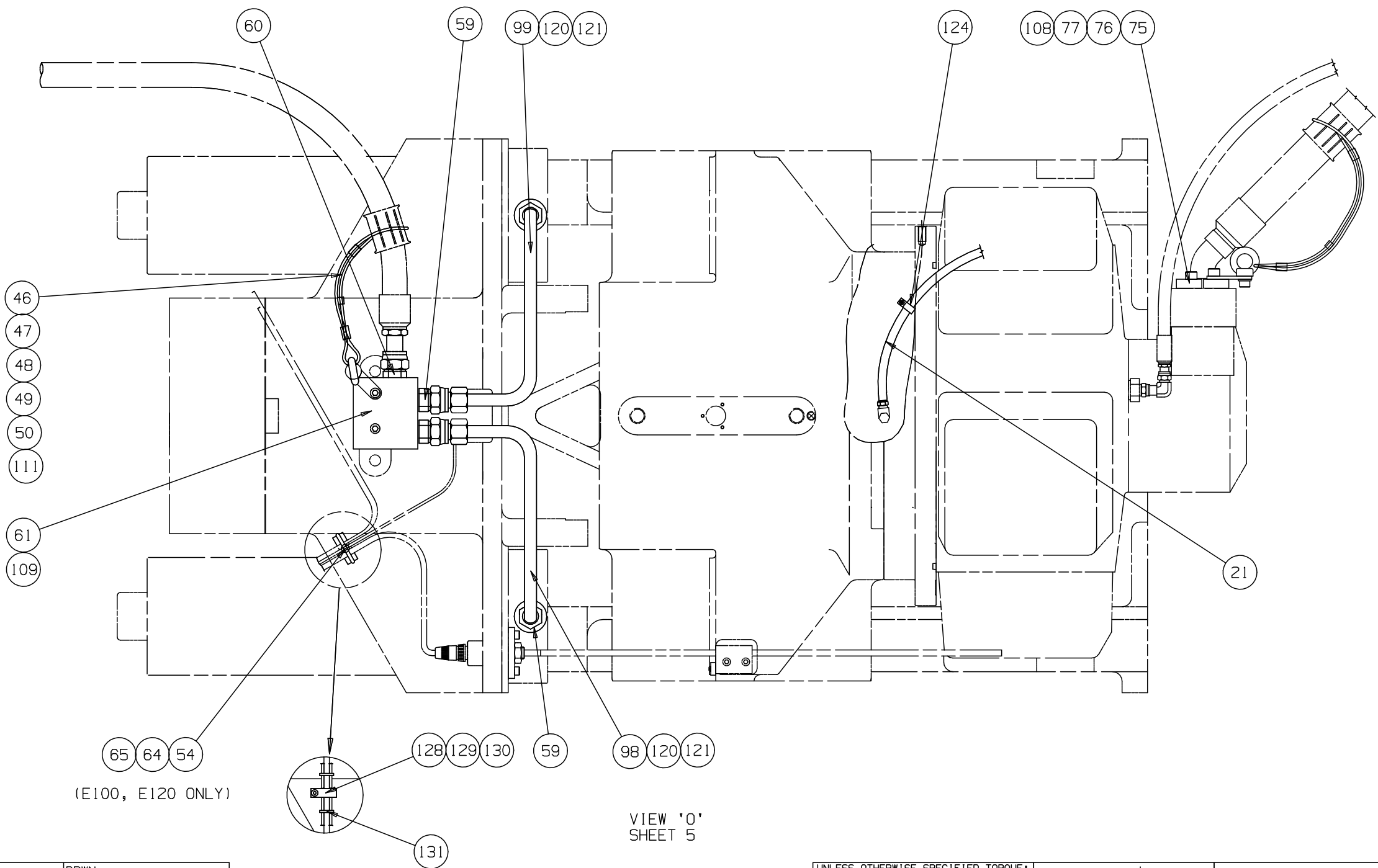
1

2

1

2

DRAWING 2303471  
REV 2



(E100, E120 ONLY)

(USE FOR E140 ONLY)

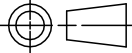
VIEW 'O'  
SHEET 5

		DRWN:	
		CHKD:	
		DRWN:	
		CHKD:	
2	2001-01-19	DRWN: B.SEKHON	
		CHKD:	
1	00-09-27	DRWN: G.SOLT1	
		CHKD: M.NEMEC	
0	2000-08-08	DRWN: B.SEKHON	
		CHKD:	
REV	DATE	NAME	

WEIGHT - kg

UNLESS OTHERWISE SPECIFIED, TORQUE:		
FASTENERS- CHART BELOW		
SIZE	Nm	lb-ft
M6	10	7
M8	18	13
M10	25	18
M12	40	30
M14	70	52
M16	95	70
M18	180	133
M20	270	200
M24	390	290
M30	660	490
M36	1300	960
M42	2300	1700
M48	3700	2700
M54	5500	4000

APPLY PROPER LUBRICANT TO ALL THREADS & CONTACTING SURFACES BEFORE INSTALLATION.

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HUSKY		INJECTION MOLDING SYSTEMS LTD	
TITLE			
INJECTION ASSEMBLY G-LINE PET P2			
SCALE	NTS	SIZE	DRAWING
SHEET 7 OF 7		A3	2303471
			REV 2